



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4297-3
Job Sheet 168893



Part No: D4297-3

Job Qty: 6 ea

Part Name: Bearpaw



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/24/17

Job Tracking No:

Due Date: 12/11/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV C IPP REV:A NEW ISSUE 12-07-25 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea		12/8/17	0.00	0.00	Start Up Container		DC
120	Waterjet	6 pcs		12/8/17	0.00	1.69	Waterjet1		DC
130	CNC Vertical Machining	6 pcs		12/11/17	0.00	11.95	HAAS 1		SC - /FK 12-128
140	QC	6 pcs		12/11/17	0.00	0.00	QC2		SC - /FK 12-128
150	QC	6 pcs		12/11/17	0.00	0.00	QC8		FK 12/12/11
151	Packaging	6 pcs		12/11/17	0.00	0.00	Packaging3	ST 13/11	SK
190	QC21-SA	6 Ea		12/11/17	0.00	0.00	QC21		SK

Part Op 120 - Cut Blank as per D2432 File (SAME BLANK AS D2432)

Descriptions: 130 - 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio FA127 and DWG-DWG

REV: FOLIO REV: 3-Deburr

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	MUHMWB10	22	1,185	0	0

Part Specifications

Specifications could not be found.

Plex 11/24/17 8:10 AM dart.poulin.mario

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Repack ☐ Engineering ☐ Quality ☐ Other ☐						
Date : _____	Step #: _____	QTY E _____		) Approval _____				
Description Work Order Deviation								
Root Cause <table style="width:100%;"> <tr> <td style="width:50%;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:50%;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> </tr> </table>		Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	<table style="width:100%;"> <tr> <td style="width:50%;"> Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ </td> <td style="width:50%;"> Temperature/Cur ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/D ☐ Inspection Incomp ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomp ☐ Drill Holes ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cur ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/D ☐ Inspection Incomp ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomp ☐ Drill Holes ☐
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OTHER : _____								

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CANADA

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**S015512**

Bearpaw

D4297 - 3**Start up Operation**

Mfg Date: 11/29/17

Job No: 168893

PART NO:
Revision:
Operation:
Change No:

DART AEROSPACE LTD		Work Order:	168893
Description: Bearpaw		Part Number:	D4297-3
Inspection Dwg: D4297 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	0.063x45°	✓		Ver.	ED-6
B	0.25 x 45°	+/-0.030	0.23x45°	✓		TAPE	
C	R0.250	+/-0.030	R0.250	✓		R.G.	
D	0.63	+/-0.030	0.625	✓		Ver.	ED-6
E	0.38	+0.030/-0.010	0.390	✓		Ver.	ED-6
F	0.95	+0.030/-0.030	0.945	✓		Ver	ED-6
G	19.000	+/-0.030	19.000	✓		TAPE	
H	Ø0.260	+0.005/-0.001	0.260	✓		G.P.	
I	Ø0.93	+/-0.030	Ø0.93	✓		Ver	ED-6
J	0.30	+0.030/-0.000	0.310	✓		Ver	ED-6
K	23.750	+/-0.030	23.750	✓		TAPE	
L	2.00	+/-0.030	2.00	✓		Ver	ED-6
M	0.47	+/-0.030	0.47	✓		Ver	ED-6
N							
O							
P							
Q							
R							
S							
T							
U							

Measured by: S.C./F.K.	Audited by: [Signature]	Preliminary Approval:
Date: 17/12/08	Date: 17/12/01	Date:

Rev	Date	Change	Revised by	Approved
A	15.02.03	New Issue	KJ	
B	15.02.09	Dimensions revised	KJ	[Signature]

